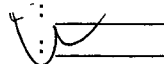


Date: Wednesday, 11/04/2007 8:57:10 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.	Drawing Name : D3537-1
Job Number : 31741	
Estimate Number : 10804	
P.O. Number :	Part Number : D35371
This Issue : 11/04/2007 S.O. No. :	Drawing Number : CUSTOM-H/D WELDS
Prsht Rev. : NC	Project Number :
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision :
Previous Run : 00015	Material :
Written By :	Due Date : 13/04/2007 Qty: 18 Um: Each
Checked & Approved By : 	
Comment :	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



(18x)

Comment: HAND FINISHING RESOURCE #1

PULL FROM STOCK

18 X D3537-1 B

31741 B30757

REMOVE PAINT WITH PAINT STRIPPER

M.L. 07/04/11

2.0	D35371	WEARPAD
-----	--------	---------



(18x)

Comment: Qty.: 1.0000 Each(s)/Unit Total: 18.0000 Each(s)

WEARPAD

M.L. 07/04/11

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



(18x)

Comment: LARGE FABRICATION RESOURCE 1

CLEAN PROPERLY WITH A WIRE BRUSH

M.L. 07/04/11

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

07/04/11

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

WELD AS PER DRWG D3537 - MARKED UP BY SERGE

HEAVY DUTY HARD FACING

A7560/3-2 B 1072755

FC 07 04 12 (18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/04/2007 8:57:10 AM  
User: Linda Lacelle

## Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D3537-1

Job Number: 31741

Part Number: D35371

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	QC5/9	WELD INSPECTION
-----	-------	-----------------



Comment: WELD INSPECTION

07/04/12

18

7.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



Comment: POWDER COATING  
REPAINT GREY SANTEX PER QSI 005

M19720

m.l

07/04/12

18x

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

4 07-04-12

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1  
RESTOCK USING NEW B/N  
USE FOR TUBES - 30967A & 30968A ONLY

u

07-04-13

sel  
30967A  
968A

10.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 07-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

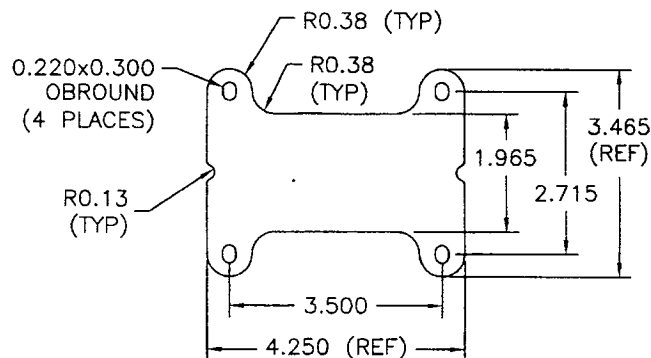
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

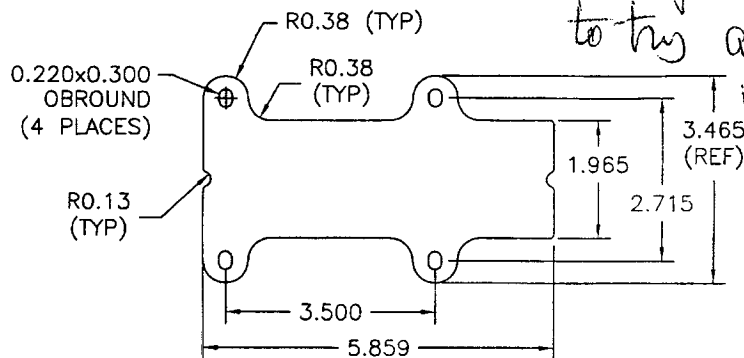
NOTE: Date & initial all entries

30967A  
30968A

### D3537-1F FLAT PATTERN

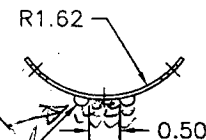


### D3537-3F FLAT PATTERN



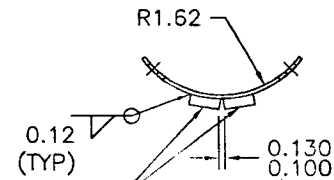
*Additional welds  
are for customer  
to try and give  
us a feel/bulk  
as per Bill  
Buckett,  
Mh*

### SECTION A-A



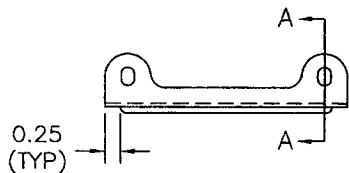
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.063 TO 0.125 THICK

### SECTION B-B

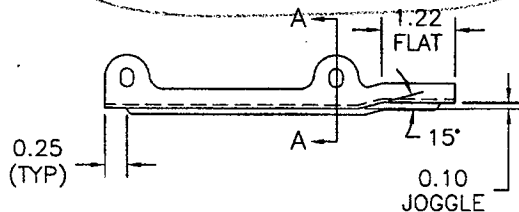


D3537-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

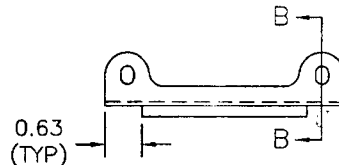
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



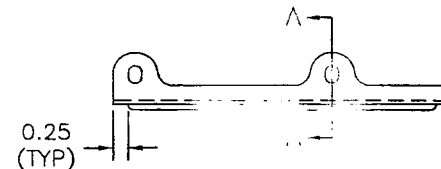
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



RELEASED  
07.02.12

### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 16 GAUGE  
(0.063 THICK, REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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A	06.11.06	NEW ISSUE	
DESIGN	CB	DRAWN	CB
CHECKED	PH	APPROVED	PH
DATE	06.11.06	DRAWING	D3537
		TITLE	WEARPAD
		SCALE	1:2

DART AEROSPACE USA, INC.  
PORT HADLOCK, WA

REV. A  
SHEET 1 OF 1